

Work Order ID 53072

October 22, 2009 2:26:42 PM



Page 1

Item ID: D130-780-044

Accept



Setup Start



Revision ID: B

Stop



Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *RL*

Date: *09/10/22*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D130-780

B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels per PPP D130-780-044 CHG 001

N/A

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

RT

10-07-14

120

0.00



Small Fab

Memo

0.00

Small Fab

ASSEMBLE PER DWG

13186

10/10/22

RT

10-07-22

Work Order ID 53072

October 22, 2009 2:26:42 PM



Page 2

Item ID: D130-780-044

Accept



Setup Start



Revision ID: B

Stop



Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	8 10/07/22			(X)			
140 Packaging Packaging	Pick Kit Memo	0.00 0.00	N/A			10.7.235f			
150 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00	8 10/07/23			(X)			

Work Order ID 53072

October 22, 2009 2:26:42 PM



Page 3

Item ID: D130-780-044

Accept



Setup Start



Revision ID: B

Stop



Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPP D130-780-044

Location: 40 53060 ~~D130-780-042~~

PPP Rev: _____

PP 53060

Rev A

10/21/22 ①

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/26

MF
10-7-23

Picklist Print

October 22, 2009 2:26:46 PM

Page 1

Work Order ID: 53072

Parent Item: D130-780-044RevA

Parent Item Name: Spacepod Door Assembly, RH




Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3186-4RevE		Manufactured	No			110	Each	0.0000	1.0000			
												
Spacepod Door, RH												
D2464-1250RevB		Manufactured	No			110	Each	0.0000	1.0000			
												
Neoprene Seal												
D3837-4RevB		Manufactured	No			110	Each	5.0000	1.0000			
												
Decal												

B53084

RT 10-07-13

B48173

RT 10-07-13

RT 10-07-14

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 5

46233 5

D2586RevD

Manufactured No

110 Each

107.0000 2.0000



M57917

x1

RT 10-07-14

Door Latch

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 107

23082 0

45554 1

47183 6

50213 100

Picklist Print

October 22, 2009 2:26:46 PM

Page 2

Work Order ID: 53072

Parent Item: D130-780-044RevA

Parent Item Name: Spacepod Door Assembly, RH

Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2585RevB

Manufactured

No

110

Each

47.0000

2.0000



Mounting Channel

59118



ST

10-07-14

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4

45888

4

Main Warehouse

ST37

43

50544

4

51526

39

D2621RevB

Manufactured

No

110

Each

68.0000

2.0000



Latch Plate, 350 Spacepod

B56526



ST 10-07-14

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

68

46842

68

October 22, 2009 2:26:46 PM

Shop Packet Print

Page 2

Picklist Print

October 22, 2009 2:26:46 PM

Page 3

Work Order ID: 53072

Parent Item: D130-780-044RevA

Parent Item Name: Spacepod Door Assembly, RH


Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-15  Screw		Purchased	No			110	Each	180.0000	2.0000			

M 114056

RT 10-07-14

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	180	
106903	3	
108169	4	
109321	4	
111916	69	
112794	100	

NAS1149D0363J

Purchased

No

110

Each

2.0000

2.0000



Washer

M 115107

RT 10-07-14

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
112314	2	

October 22, 2009 2:26:46 PM

Shop Packet Print

Page 3

Picklist Print

October 22, 2009 2:26:46 PM

Page 4

Work Order ID: 53072

Parent Item: D130-780-044RevA

Parent Item Name: Spacepod Door Assembly, RH


Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3  Nut		Purchased	No			110	Each	3,430.000	2.0000			

114523

ST 10-07-14

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3430	
110844	32	
111274	35	
111668	863	
112314	2000	
112385	500	

D2857-1RevB

Manufactured No

110 Each

18.0000 1.0000



57924

ST 10-07-14

Hinge Bracket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	18	
41166	7	
45788	5	
50235	6	

October 22, 2009 2:26:46 PM

Shop Packet Print

Page 4

Picklist Print

October 22, 2009 2:26:46 PM

Page 5

Work Order ID: 53072

Parent Item: D130-780-044RevA

Parent Item Name: Spacepod Door Assembly, RH




Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2857-2RevB  Hinge Bracket		Manufactured	No			110	Each	14.0000	1.0000			
55020												
				<u>Warehouse</u>	<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
				Main Warehouse								
				ST			14					
				45797			14					
D2228RevB  Bracket Plate		Manufactured	No			110	Each	80.0000	2.0000			
x4												
				<u>Warehouse</u>	<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
				Main Warehouse								
				ST			80					
				30679			37					
				48228			43					
AN526C832R10  Screw		Purchased	No			110	Each	105.0000	10.0000			
m113 288												
				<u>Warehouse</u>	<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
				Main Warehouse								
				ST			105					
				104603			105					

10-07-14

10-07-14

10-07-14

October 22, 2009 2:26:46 PM

Shop Packet Print

Page 5

Picklist Print

October 22, 2009 2:26:46 PM

Page 6

Work Order ID: 53072

Parent Item: D130-780-044RevA

Parent Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

NAS1149DN832J		Purchased	No			110	Each	375.0000	12.0000			
---------------	--	-----------	----	--	--	-----	------	----------	---------	--	--	--



WASHER

114883



37

10-07-14

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST	375	
111193	3	
111359	72	
112385	300	

MS21042L08		Purchased	No			110	Each	407.0000	12.0000			
------------	--	-----------	----	--	--	-----	------	----------	---------	--	--	--



Nut

114330



37

10-07-14

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST	407	
110002	24	
111889	51	
112243	47	
112492	85	
112612	100	
112794	100	

October 22, 2009 2:26:46 PM

Shop Packet Print

Page 6

Picklist Print

October 22, 2009 2:26:46 PM

Page 7

Work Order ID: 53072

Parent Item: D130-780-044RevA

Parent Item Name: Spacepod Door Assembly, RH

Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3557-1RevA

Manufactured

No

110

Each

23.0000

1.0000



Bracket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

23

32647

1

46887

7

50283

15

D3554-7RevA

Manufactured

No

110

Each

60.0000

1.0000



Ball Stud

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

60

37674

60

NAS1149D0563J

Purchased

No

110

Each

100.0000

1.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

100

112794

100

W 114742

October 22, 2009 2:26:46 PM

Shop Packet Print

Page 7

Picklist Print

October 22, 2009 2:26:46 PM

Page 8

Work Order ID: 53072

Parent Item: D130-780-044RevA

Parent Item Name: Spacepod Door Assembly, RH

Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3015-3RevB

Manufactured

No

110

Each

328.0000

1.0000



Locknut

M58202



21 10-07-14

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

128

43758

26

44446

49

48238

53

Main Warehouse

ST59

200

51711

200

AN526C832R14

Purchased

No

110

Each

937.0000

2.0000



Screw



21 10-07-14

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

937

104916

937

21

October 22, 2009 2:26:46 PM

Shop Packet Print

Page 8

Picklist Print

October 22, 2009 2:26:46 PM

Page 9

Work Order ID: 53072

Parent Item: D130-780-044RevA

Parent Item Name: Spacepod Door Assembly, RH

Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2589RevA

Manufactured

No

140

Each

61.0000

1.0000

Keys, Key Chain, 350 Hinge

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

61

46840

21

50378

40

D3552-7RevD

Manufactured

No

140

Each

12.0000

1.0000

Door Prop

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

12

52451

12

MS27039-08-11

Purchased

No

Each

78.0000

2.0000

Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

78

111977

78

October 22, 2009 2:26:46 PM

Shop Packet Print

Page 9

Picklist Print

October 22, 2009 2:26:46 PM

Page 10

Work Order ID: 53072

Parent Item: D130-780-044RevA

Parent Item Name: Spacepod Door Assembly, RH


Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1149DN832J  WASHER		Purchased	No				Each	375.0000	4.0000			

Handwritten: 140-110
m 114 883

Handwritten: 2F 2T 10-07-14

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	375	
111193	3	
111359	72	
112385	300	

NAS1515H3  Washer	Purchased	No
--	-----------	----

Handwritten: 140-110

Handwritten: 2T 10-07-14

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	490	
109268	259	
110397	87	
111268	144	

Handwritten: x2

October 22, 2009 2:26:47 PM

Shop Packet Print

Page 10

Picklist Print

October 22, 2009 2:26:47 PM

Page 11

Work Order ID: 53072



Parent Item: D130-780-044RevA



Parent Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L08

Purchased

No



Nut

100 F10

Each

407.0000

2.0000



M 114330 x 2

ET

10-07-14

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

407

110002

24

111889

51

112243

47

112492

85

112612

100

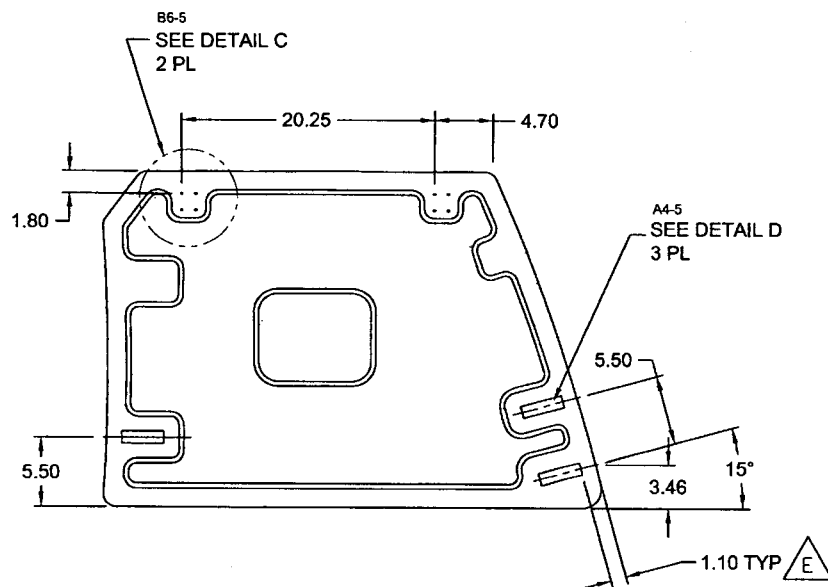
112794

100

October 22, 2009 2:26:47 PM

Shop Packet Print

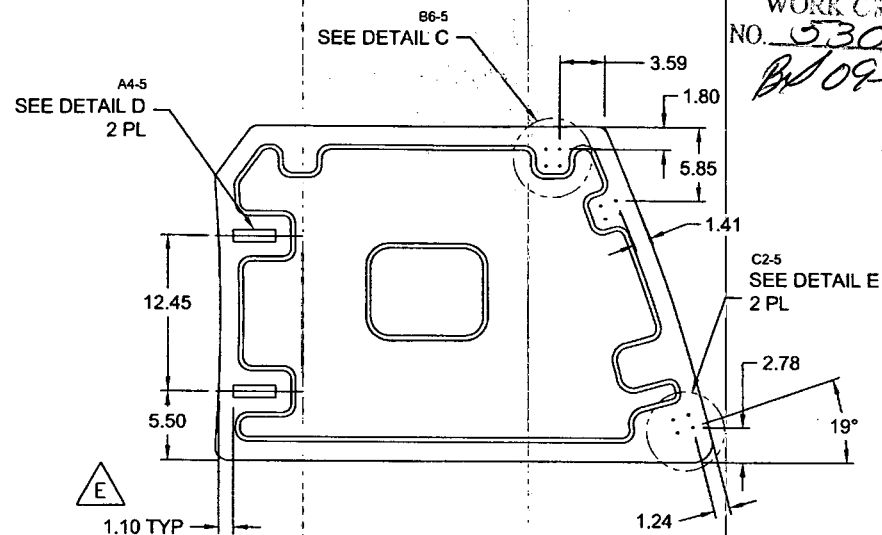
Page 11



D3186-1 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



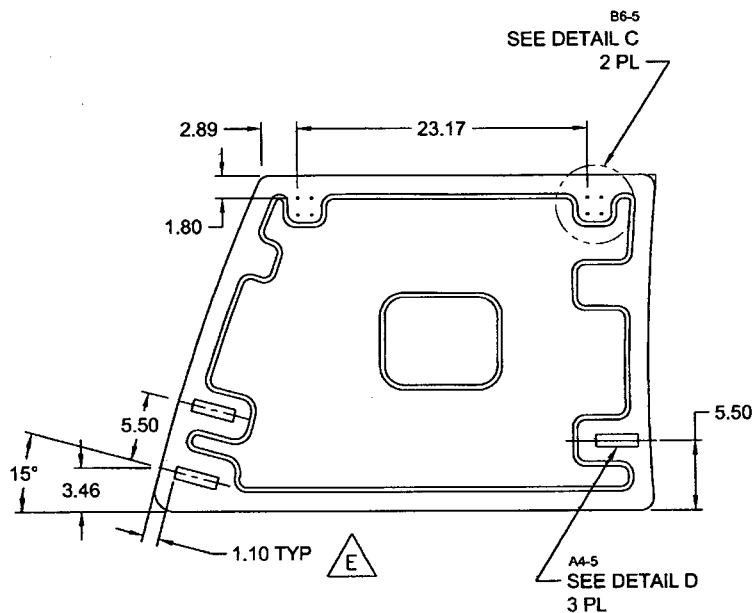
D3186-3 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53072
BA 09-1022

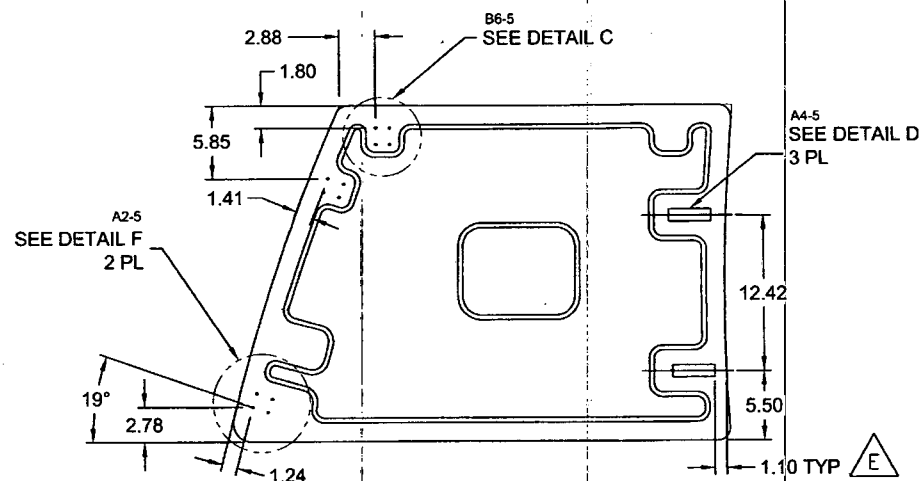
RELEASED
2009-09-09

E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026	RF	09.07.08
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	LE	06.09.25
A	NEW ISSUE	CP	03.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	IP	DRAWING NO.	REV. E
MFG. APPR.	AD	D3186	SHEET 1 OF 5
APPROVED	AD	TITLE	SCALE
DE APPR.	AD	SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

53072



D3186-2 SPACEPOD DOOR, RH
MAKE FROM D3186-2M



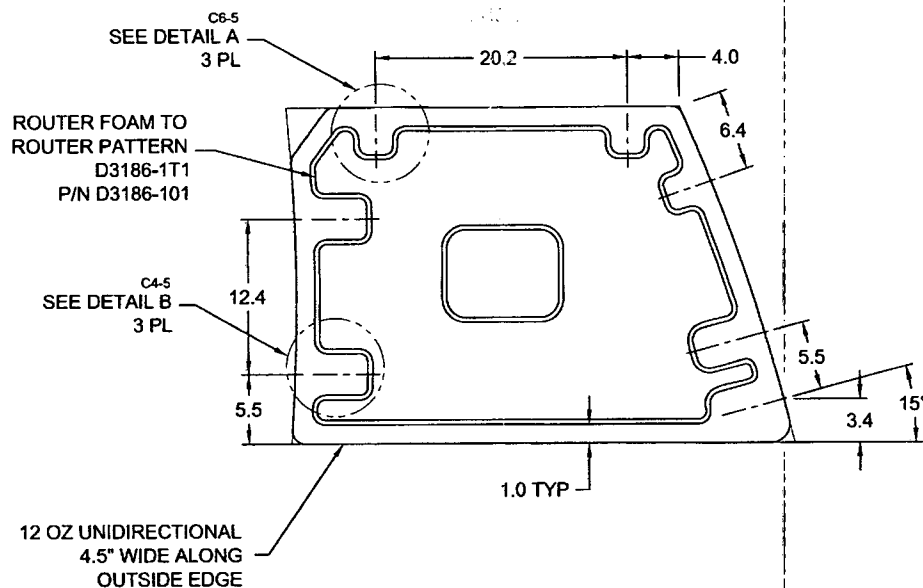
D3186-4 SPACEPOD DOOR, RH
MAKE FROM D3186-2M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

RELEASED
2009-09-09

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GR	DRAWING NO.	REV. E
MFG. APPR.	MD	D3186	SHEET 2 OF 5
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	SPACEPOD DOOR	NTS
DATE	09.07.08	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3186-1M SPACEPOD DOOR AS MOLDED

NOTES:

1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL

FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")

12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")

LAMINATE PER DART QSI 006 4.0

LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

8) USE MOLD DT8005 FOR DOOR LAYUP

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)

9 OZ SATIN (9 SQ FEET)

FOAM

9 OZ SATIN (9 SQ FEET)

12 OZ UNIDIRECTIONAL

9 OZ SATIN (9 SQ FEET)

RESIN (35-45% BY WEIGHT)

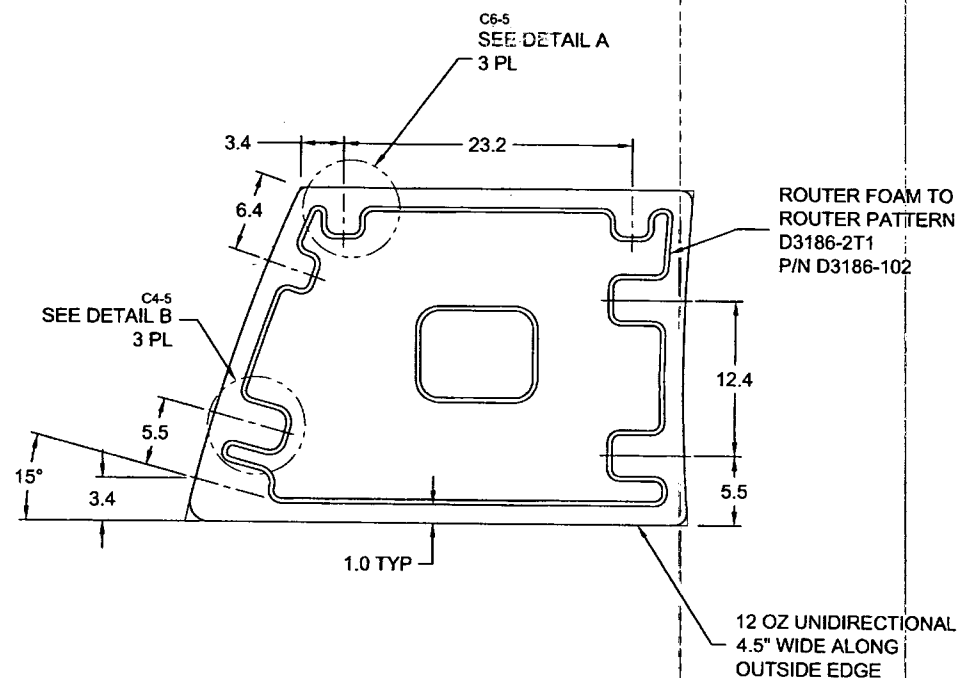
PEEL PLY

RELEASED
2009-09-08

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY



D3186-2M SPACEPOD DOOR AS MOLDED

NOTES:

1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8" A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
LAMINATE PER DART QSI 006 4.0
LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED





5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

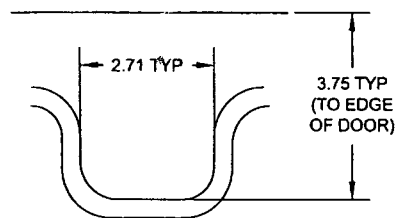
7) WEIGHT: 7.0 lbs

8) USE MOLD DT8006 FOR DOOR LAYUP

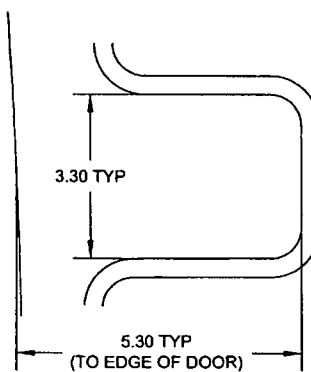
RELEASED
2009-09-09

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIAL OR DOMESTIC PURPOSE WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

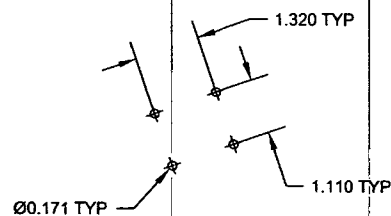
53077



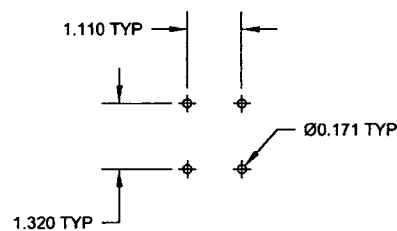
DETAIL A D6-3
SCALE 4X D4-4



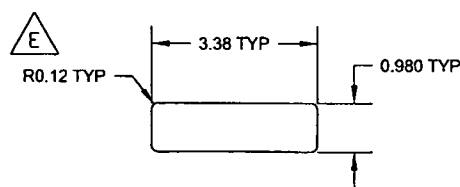
DETAIL B C6-3
SCALE 4X C6-4



DETAIL E C1-1
SCALE 4X

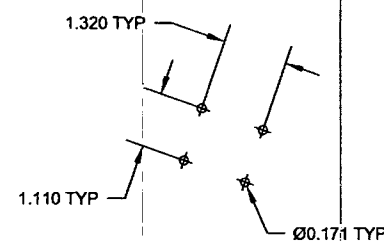


DETAIL C D7-1
SCALE 4X D3-1
D6-2
D3-2







NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D C5-1
SCALE 4X D4-1
B6-2
C2-2



DETAIL F C4-2
SCALE 4X

RELEASED
2009-09-09

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			